

518

WFO

SPLIT

DART AEROSPACE LTD	Work Order:	23001A
Description: Hub Sleeve	Part Number:	D3233-5
Dwg: D3233 Rev. B PAGE 3 OF 15	Qty:	348 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.13	34
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) Identify for D3233-5		5.6 05/06/14	34
3	QC2	Inspect parts as they come off the machine Identify as D3233-5	5.6	05/06/15	34
4	CM	Mill as per Dwg D3233	EZ	05.06.15	8
5	QC8	Second check	RD	05.06.15	8
6	CM	Deburr	CL	05/06/15	8
7	QC5	Inspect work to Step 6	Z	05.06.15	8
8	ST	Identify and Stock	CFK	05/06/15	8
9	AC	Cost / part 2.86	AB	05/06/16	8
10	DC	Close W/O 2.84 Inspect Level 21	KJ	05.06.17	8

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	JLM

RELEASED
RJ/15/03/15

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	05.03.08	DRAWING NO.	REV. B
		D3233	SHEET 3 OF 3

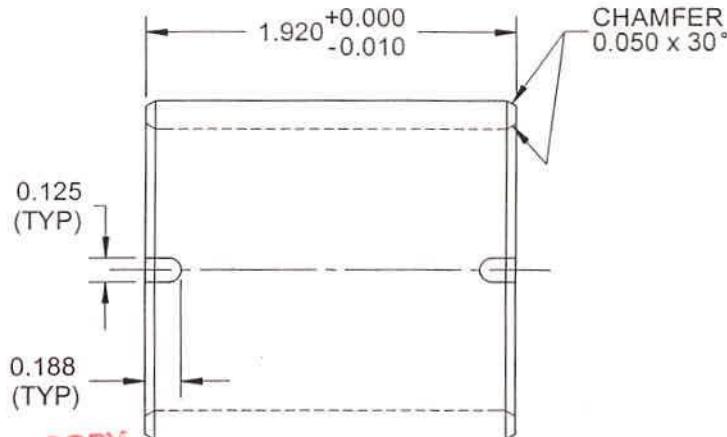
TITLE

WHEEL ASSEMBLY

SCALE

1:1

RELEASED
MS
05/05/04



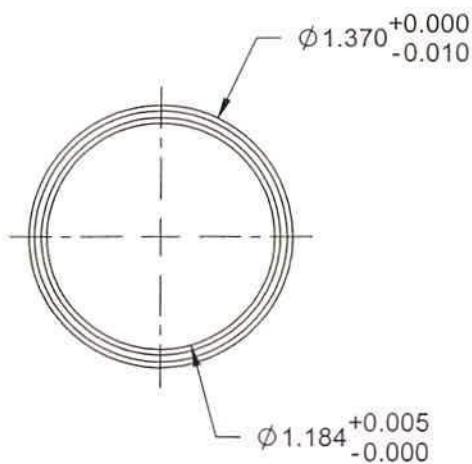
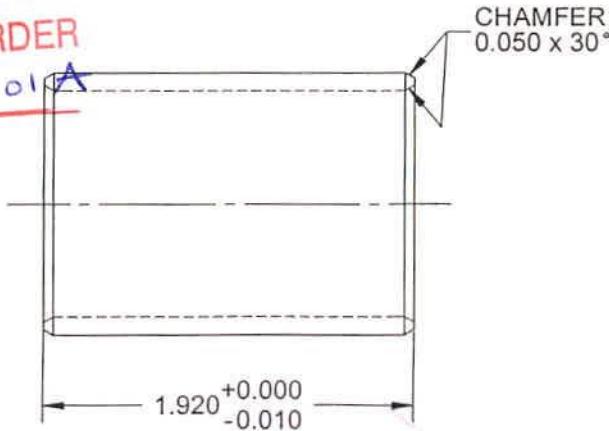
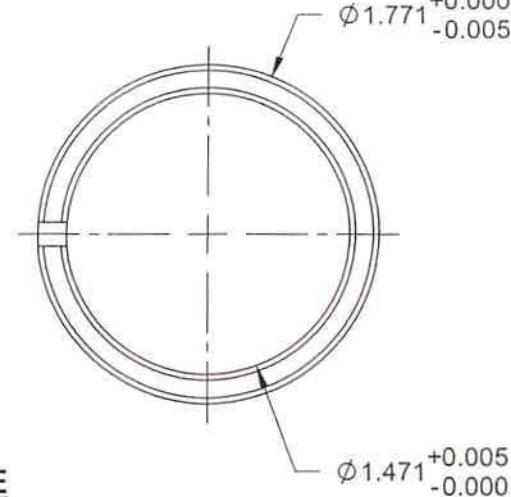
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23001

D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

DART AEROSPACE LTD	Work Order:	23001
Description:	Part Number:	D3233-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Job Costing Report

Dart Aerospace Ltd.
HawkesburyApr 12, 2005
02:25 pm

Work Order No : 0023001
 Project Name : D3233-5
 Project For : WK518
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3233-5
 Description : Hub Sleeve
 Manufactured : Yes
 Amount Req'd : 34
 Amount Done : 0
 Start Date : 04-12-05
 Est Finish Date : 04-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00*	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Total Cost :	0.00	0.00	0.00	0.00	
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00